

Date: Thursday, 14/08/2008 8:32:26 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: INSTRUMENT PANEL WELDMENT		
Job Number	: 41227					
Estimate Number	: 13167					
P.O. Number	:		Part Number	:	D3705043	08-08-14 Rev B
This Issue	: 14/08/2008	S.O. No. :	Drawing Number	:	D3705 PROTO	
Prsh Rev.	: NC		Project Number	:	N/A	
First Issue	: / /	Type : R & D LG FAB	Drawing Revision	:	PROTO	
Previous Run	: 37302		Material	:		
Written By	:		Due Date	:	15/08/2008	Cty: 1 Um: Each
Checked & Approved By	: JMF 08-08-14					
Comment	: Est Rev:A new issue 08-05-30 DD verified by:ec					

PRELIMINARY ISSUE

08-08-14

~~PROTOTYPE~~

POSITIVE RECALL

FOR ENGINEERING USE ONLY

Additional Product

Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
			Comment: PACKAGING RESOURCE #1 Pick Packing Kit
2.0	D37051	MAIN PANEL	
			Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) MAIN PANEL batch B41225 PD 08-08-15
3.0	D37053	COVER PLATE	
			Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) COVER PLATE batch B41226 PD 08-08-15
4.0	D37061	Lock Bracket	
			Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lock Bracket batch B05023 05023
5.0	D37063	Guide	
			Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Guide batch B05022 PD 08-08-15

Date: Thursday, 14/08/2008 8:32:26 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSTRUMENT PANEL WELDMENT

Job Number: 41227

Part Number: D3705043

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble and weld as per dwg D3705 per QSI004

*****nice weld all arround and buff weld smooth****

Aluminum rod batch: M106330

PD 08/08/15 ①

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/08/15 ②

8.0 QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

08.08.20 ①

9.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08/08/15 ③

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

1:00
01=

OVEN TEMPERATURE:

320
1:30

FINISH TIME:

M-1 08/08/19

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/08/19 ④

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

09.08.16

✓

- Q.1 ~~Q.3~~ ~~Q.2~~ ~~Q.1~~ Q.1
MS20126AΔ3-3 Right back; H1563 Q.TY 28 63
- ① 08-08-18 ~~ff~~ MS20125L3 nut plate back; H100257 Q.TY 14
- Q.2 ~~Q.3~~ ~~Q.2~~ ~~Q.1~~ Q.1
MS20126AΔ3-3 Right back; H1563 Q.TY 28 63
- ① 08-08-18 ~~ff~~ MS20126AΔ3-3 Right back; H1563 Q.TY 28 63
- Q.3 ~~Q.3~~ ~~Q.2~~ ~~Q.1~~ Q.1
MS20126AΔ3-3 Right back; H1563 Q.TY 28 63
- ① 08-08-18 ~~ff~~ MS20126AΔ3-3 Right back; H1563 Q.TY 28 63
- Q.4 ~~Q.3~~ ~~Q.2~~ ~~Q.1~~ Q.1
MS20125L3 nut plate back; H100257 Q.TY 14
- ① 08-08-18 ~~ff~~ MS20125L3 nut plate back; H100257 Q.TY 14
- Q.5 ~~Q.3~~ ~~Q.2~~ ~~Q.1~~ Q.1
MS20126AΔ3-3 Right back; H1563 Q.TY 28 63
- ① 08-08-18 ~~ff~~ MS20126AΔ3-3 Right back; H1563 Q.TY 28 63

Date: Thursday, 14/08/2008 8:32:26 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSTRUMENT PANEL WELDMENT

Job Number: 41227

Part Number: D3705043

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



09/02/17 HJ



1008.08.22 Prototype

Comment: FINAL INSPECTION/W/O RELEASE

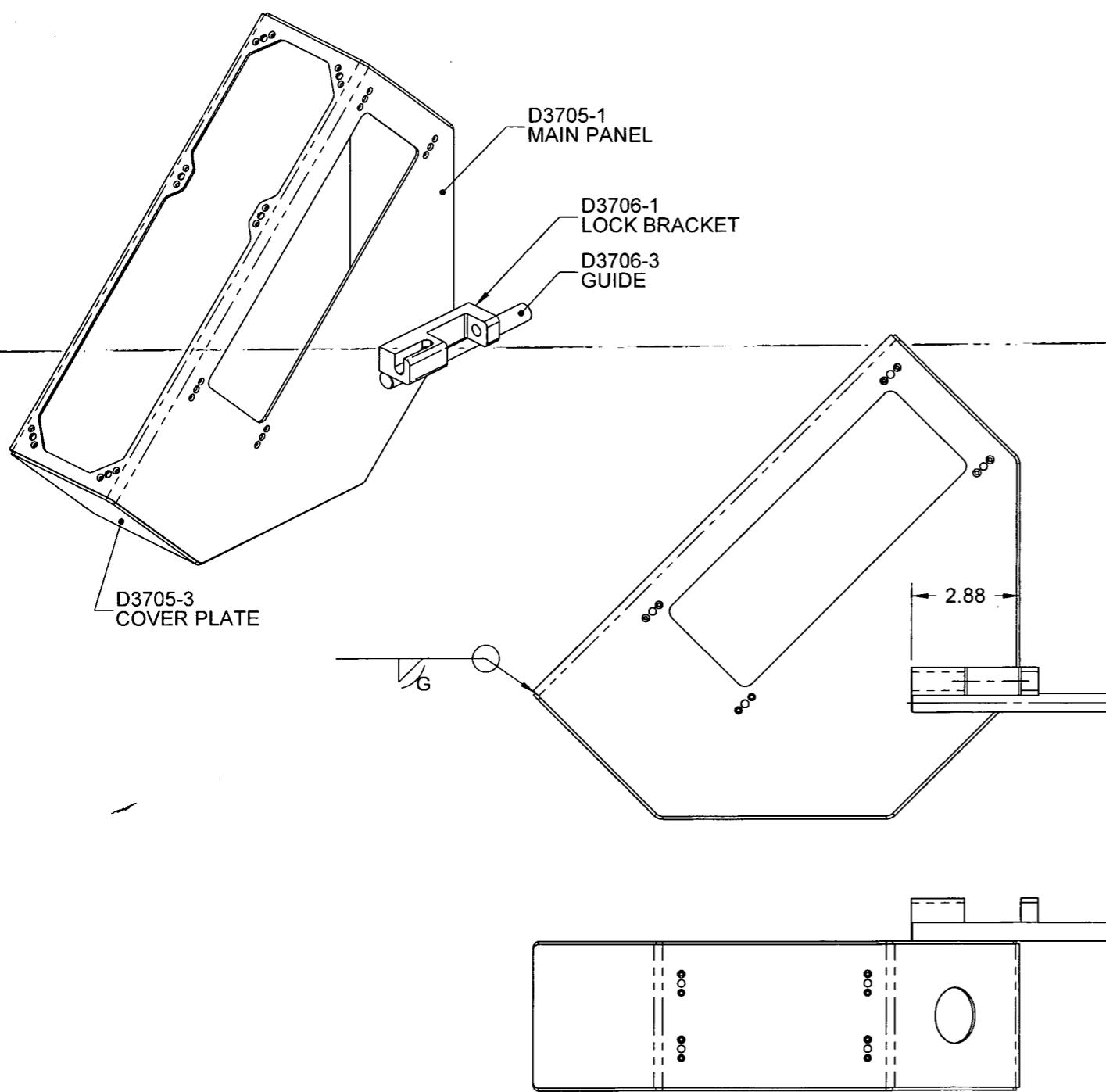
Job Completion



u 09-01-26

POSITIVE RECALL
EFFECTIVE 08.08.22 AUTH u
RELEASED _____ DATE 06.02.12

8 7 6 5 4 3 2 1



-043 QTY.	P/N	DESCRIPTION
X	D3705-043	INSTRUMENT PANEL WELDMENT
1	D3705-1	MAIN PANEL
1	D3705-3	COVER PLATE
1	D3706-1	LOCK BRACKET
1	D3706-3	GUIDE

D3705-043 INSTRUMENT PANEL WELDMENT

D3705-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.90 lbs
- 8) WELDING: PER DART QSI 004

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3705	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	NTS
DATE	08.08.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

C

B

A

A

